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D3137-3**Job Sheet 205665****Part No:** D3137-3**Job Qty:** 24 pcs**Part Name:** Guide**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 1/16/20**Job Tracking No:****Due Date:** 2/5/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV F IPP Rev:A 02.05.29 New Issue NG IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC IPP
Rev c 08.07.03 ECN1207 EC verified by DD

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	24 pcs	2/5/20	2/5/20	0.00	0.29	Bandsaw - 1		20-01-26
110	HAAS 4 Axis - B4B	24 pcs	2/5/20	2/5/20	1.00	5.62	HAAS - 1 - B4B		20-01-26
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
130	QC 8	24 pcs	2/5/20	2/5/20			QC 8 - 12		20-01-27
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



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Container No: S250758**Part:** D3137-3**Job No:** 205665**Serial No/Batch:** S250758**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 01/26/20

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				QC 8 - 76	
				QC 8 - 61	
140 Packaging 3-1 - Stock - B4B 24 pcs	2/5/20	0.00 0.00	Packaging 3 - 1 - B4B		
			Packaging 3 - 2 - B4B		
			Packaging 3 - 3 - B4B		
			Packaging 3 - 4 - B4B		
			Packaging 3 - 5 - B4B		
			Packaging 3 - 6 - B4B		
			Packaging 3 - 7 - B4B		
			Packaging 3 - 8 - B4B		
			Packaging 3 - 9 - B4B		
			Packaging 3 - 10 - B4B		
			Packaging 3 - 11 - B4B		
			Packaging 3 - 12 - B4B		
			Packaging 3 - 13 - B4B		
			Packaging 3 - 14 - B4B		
			Packaging 3 - 15 - B4B		
			Packaging 3 - 16 - B4B		
			Packaging 3 - 17 - B4B		
			Packaging 3 - 18 - B4B		
			Packaging 3 - 19 - B4B		
			Packaging 3 - 20 - B4B		
			Packaging 3 - 21 - B4B		
			Packaging 3 - 22 - B4B		
			Packaging 3 - 23 - B4B		
			Packaging 3 - 24 - B4B		
			Packaging 3 - 25 - B4B		
			Packaging 3 - 26 - B4B		
			Packaging 3 - 27 - B4B		
			Packaging 3 - 28 - B4B		
			Packaging 3 - 29 - B4B		
			Packaging 3 - 30 - B4B		
			Packaging 3 - 31 - B4B		
			Packaging 3 - 32 - B4B		
			Packaging 3 - 33 - B4B		
			Packaging 3 - 34 - B4B		
			Packaging 3 - 35 - B4B		
			Packaging 3 - 36 - B4B		
			Packaging 3 - 37 - B4B		
150 QC 21 - SA 24 pcs	2/5/20	0.00 0.00	QC 21 - SA - 21	DAS	
			QC 21 - SA - 70	21	
			QC 21 - SA - 53	9-89	

DAS
28
9-89

DAS

21

9-89

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Part Op 100 - Bandsaw - Cut Blanks. Blank size: 1.250" x .750" x .950" long
 Descriptions: 110 - HAAS CNC Vertical Machine - 1-Machine as per Folio FA242 & Dwg D3137
 130 - QC8- Inspect parts - second check
 140 - Identify as per dwg & Stock Location: _____
 150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MDELRINB0.750X1.250	Delrin Bar	1.9008 ft (0.750" ea) 0.0855	100-Bandsaw - 1	SO68422

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	MDELRINB0.750X1.250	2	48	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Guide	0.175inches $\pm$ 0.010	0.185 0.165		
2	Guide	0.257inches + 0.005 - 0.000	0.262 0.257		
3	Guide	0.650inches $\pm$ 0.010	0.660 0.640		
4	Guide	100Degrees $\pm$ 0	100 100		
5	Guide	0.425inches $\pm$ 0.010	0.435 0.415		
6	Guide	0.550inches $\pm$ 0.010	0.560 0.540		
7	Guide	1.100inches $\pm$ 0.010	1.110 1.090		
8	Guide	0.470inches $\pm$ 0.010	0.480 0.460		
9	Guide	0.850inches $\pm$ 0.010	0.860 0.840		
10	Guide	0.143inches $\pm$ 0.010	0.153 0.133		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :	MRB (QSI042)		
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			